

# Work Order ID 71213

Friday, June 24, 2011 8:12:45 AM

Page 1

Item ID: D3913-041

Revision ID:

Item Name: Long Basket Base Assembly, 350

Start Date: 6/24/2011 Start Qty: 1.00

Required Date: 6/30/2011 Req'd Qty: 1.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 11-06-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3913

A

D4020

A

100

Weld per dwg A/R S.S. rod Batch: 115928 0.00

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A

\*\*\*inspect before welding mesh\*\*\*

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D3913

\*\*\*take lid to locate hinge and bracket\*\*\*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PC 11-06-30

PC 11-06-30 1 0 BE 11/06/30

**Work Order ID 71213**

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Item ID:	D3913-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Long Basket Base Assembly, 350				Stop	
Start Date:	6/24/2011	Start Qty:	1.00			
Required Date:	6/30/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00  0.00		8 u/07/04					
125  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo	0.00  0.00							


IX 8 u/07/04








**Work Order ID 71213**

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Item ID: D3913-041 Accept  Setup Start   
Revision ID:   
Item Name: Long Basket Base Assembly, 350 Stop   
Start Date: 6/24/2011 Start Qty: 1.00  Cust Item ID:  
Required Date: 6/30/2011 Req'd Qty: 1.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish	Assemble as per dwg	0.00							
Hand Finishing	Memo Pick Kit	0.00							<i>ES 11/07/05</i> ①
160  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							<i>ES 11/07/05</i>
170  Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	<i>W6 70569</i> Memo <i>D4030-041</i>	0.00							<i>ES 11/07/05</i> ②

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Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 6/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/5 J  
MF  
11-07-05

# Picklist Print

Friday, June 24, 2011 8:12:51 AM

Page 1

Work Order ID: 71213

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/24/2011

Required Date: 6/30/2011


Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	97.0000	2	2			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	97	
68964	4	
69258	28	
69739	14	
70766	51	

D3913-1  Rib		Manufactured	No			100	Each	8.0000	1	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	7	
59089	2	
69260	2	
70346	3	
WA006	1	
69427	1	

D3913-15  Wide Handle Plate		Manufactured	No			100	Each	13.0000	1	1			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	8	
69158	4	
69647	4	
WA005	5	
69012	5	

SAD 11-06-25

SAD 11-06-25

SAD 11-06-25

①

# Picklist Print

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Page 2

Work Order ID: 71213

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-3 Manufactured No

100 Each

5.0000

1

1



Rib



SAD 11-06-25

Location

Loc Qty

Loc Code

WA

2

69160

2

WA006

3

69646

3

①

D3913-7 Manufactured No

100 Each

14.0000

2

2



Rib



SAD 11-06-25

Location

Loc Qty

Loc Code

WA

12

69521

6

70334

6

WA006

2

65278

1

66435

1

2

D3913-9 Manufactured No

100 Each

5.0000

1

1



Hinge Rib



SAD 11-06-25

Location

Loc Qty

Loc Code

WA

3

70336

3

WA006

2

70138

2

①

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Shop Packet Print

Page 2

# Picklist Print

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Page 3

Work Order ID: 71213

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3916-041

Manufactured No

100 Each

8.0000

2 2



Rib Assembly



SAD 11-06-25

Location

Loc Qty

Loc Code

WA

8

69010

2

69161

6

D3916-5

Manufactured No

100 Each

9.0000

3



Light Rib



②

SAD 11-06-25

Location

Loc Qty

Loc Code

WA

9

59088

9

D4016-1

Manufactured No

100 Each

31.0000

3



Hinge Half, Base



③

SAD 11-06-25

Location

Loc Qty

Loc Code

WA

31

66418

0

68426

13

70342

18

D4017-7

Manufactured No

100 Each

3.0000

1



Rib



②

SAD 11-06-25

Location

Loc Qty

Loc Code

WA

3

69730

3

①

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# Picklist Print

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Page 4

Work Order ID: 71213

Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4017-9	Manufactured	No	100	Each	8.0000	2	2
* 							SAD 11-06-25
Rib							

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# Picklist Print

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Page 5

Work Order ID: 71213

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D4034-043

Manufactured No

100

Each

4.0000

1

1



Fwd Upper Rib Assembly



SAD 11-06-25

Location

Loc Qty

Loc Code

WA

1

68414

1

WA006

3

70241

3

M304EX0.75-16F

Purchased

No

100

sf

354.2530

33

33



Expanded Metal Flat SS



11-006-30

Location

Loc Qty

Loc Code

MAT

38.2107

117708

38.2107

WA

316.0423

115012

95

117197

102.9036

117455

16.0341

117896

102.1046

AN3-10A

Purchased

No

150

Each

176.0000

6

6



Bolt



11/07/05

Location

Loc Qty

Loc Code

ST351

176

117313

42

117795

134

AN960JD8

NAS1149DN832J Purchased

No

150

Each

0.0000

2

2



Washer



11/07/05

4 M117313 (24)

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# Picklist Print

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Work Order ID: 71213

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No

150 Each

638.0000 2



Bumper

Location

Loc Qty

Loc Code

ST504

638

46064

638

D4021-5 Manufactured No

150 Each

23.0000 2



Blanking Plate

Location

Loc Qty

Loc Code

GA

21

70349

21

WA005

2

67008

2

MS20600-AD4W3 Purchased No

150 Each

933.0000 2



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

800

111636

114

117505

500

117601

186

WA018

133

107939

133

2  
EJS/07/05

2  
EJS/07/05

2  
EJS/07/05

2

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# Picklist Print

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Work Order ID: 71213

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,975.000

6



Nut

Location

Loc Qty

Loc Code

ST300

1975

116549

275

117441

800

117601

400

117885

500



6/24/07/05

NAS1149F0332P

Purchased

No

150

Each

210.0000

12



WASHER

Location

Loc Qty

Loc Code

ST275

210

117735

200

17317

10



12/24/07/05

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

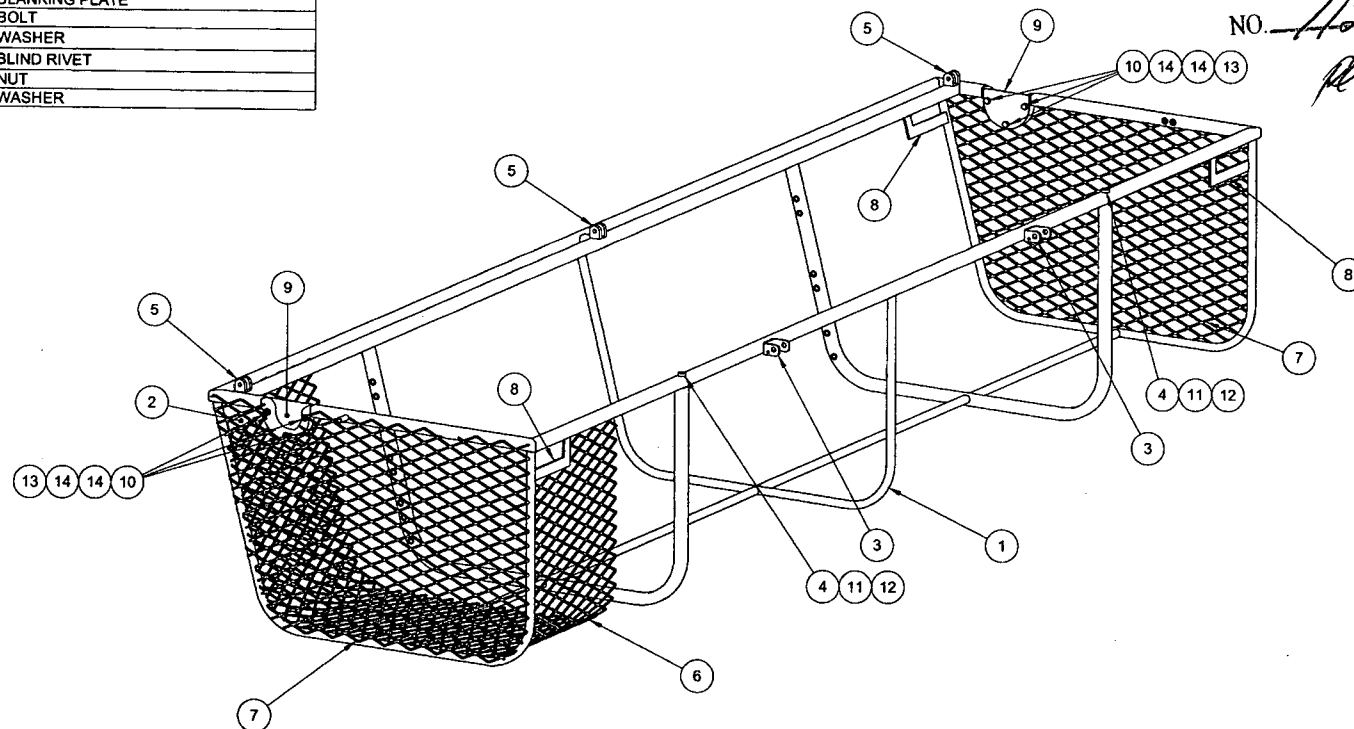
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

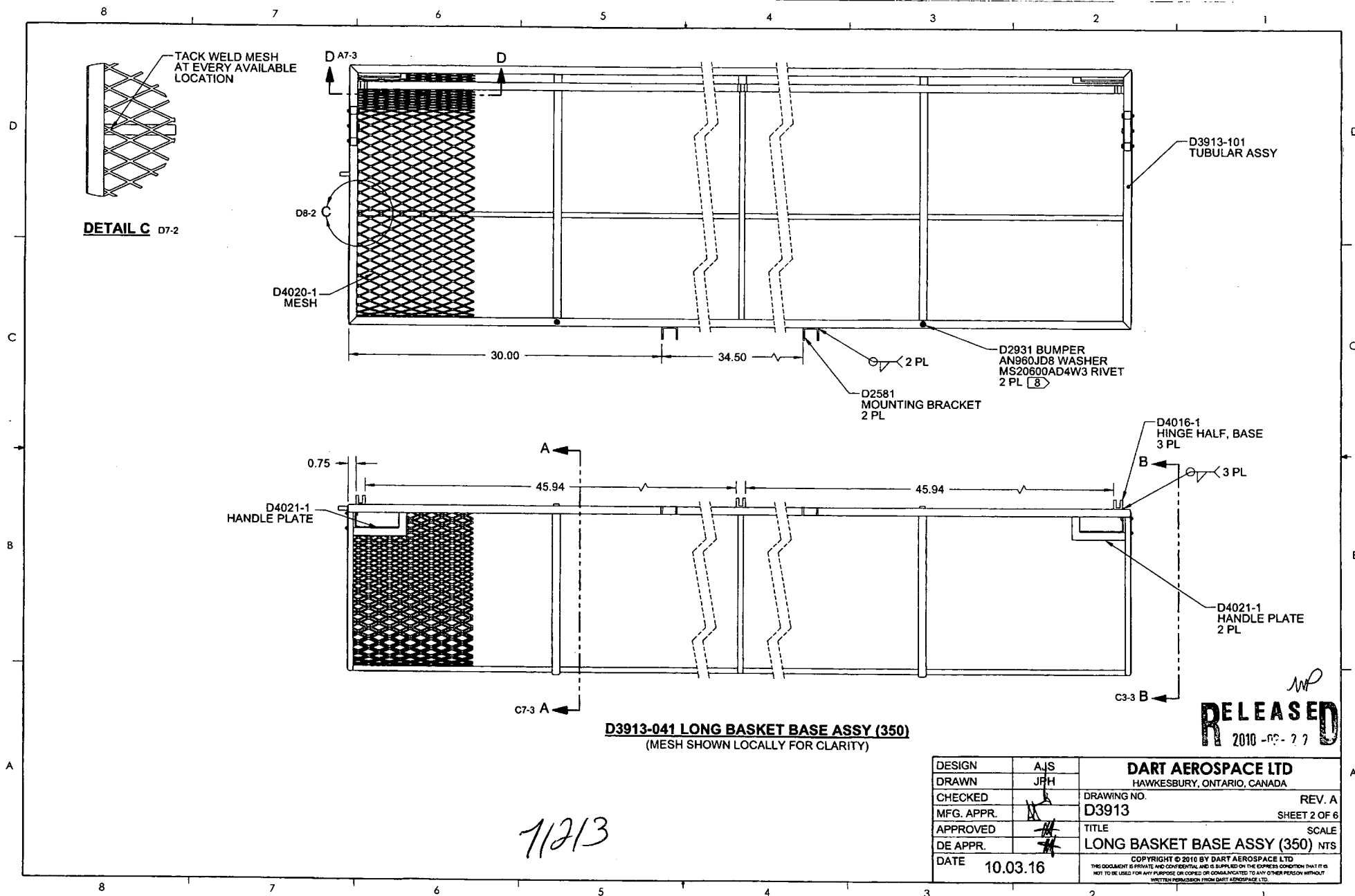
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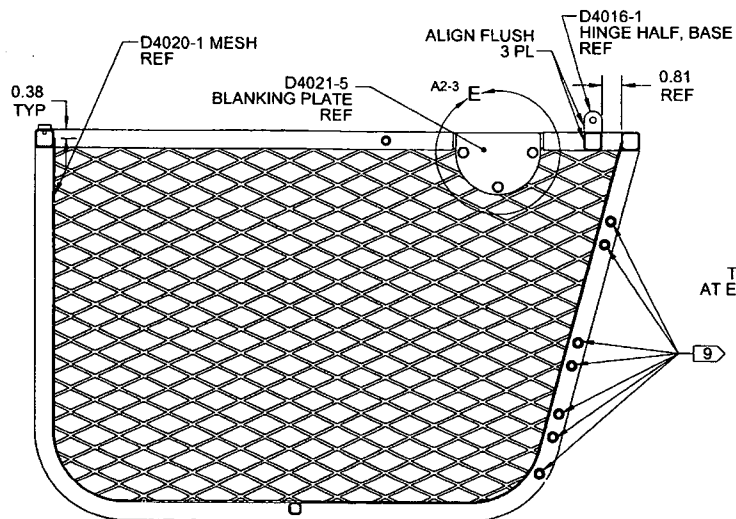
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 11213  
111-06-24

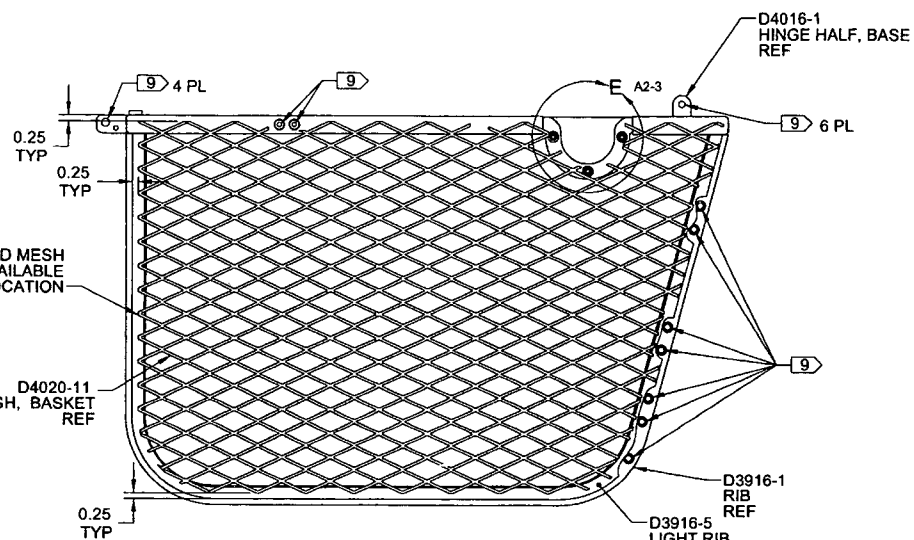
**RELEASED**  
2010-03-22  
*WJP*

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3913	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET BASE ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

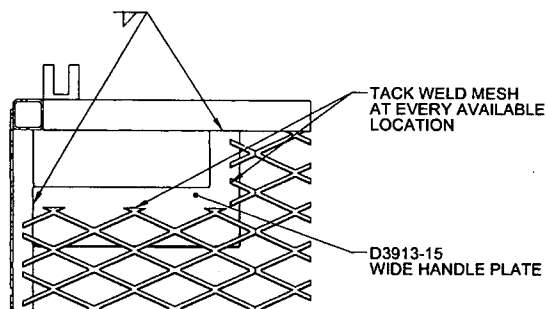




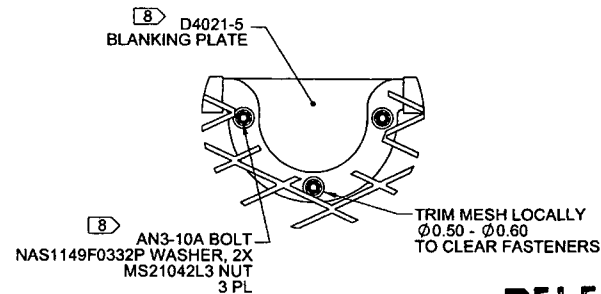
**SECTION A-A** A5-2



**VIEW B-B** A2-2







**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES



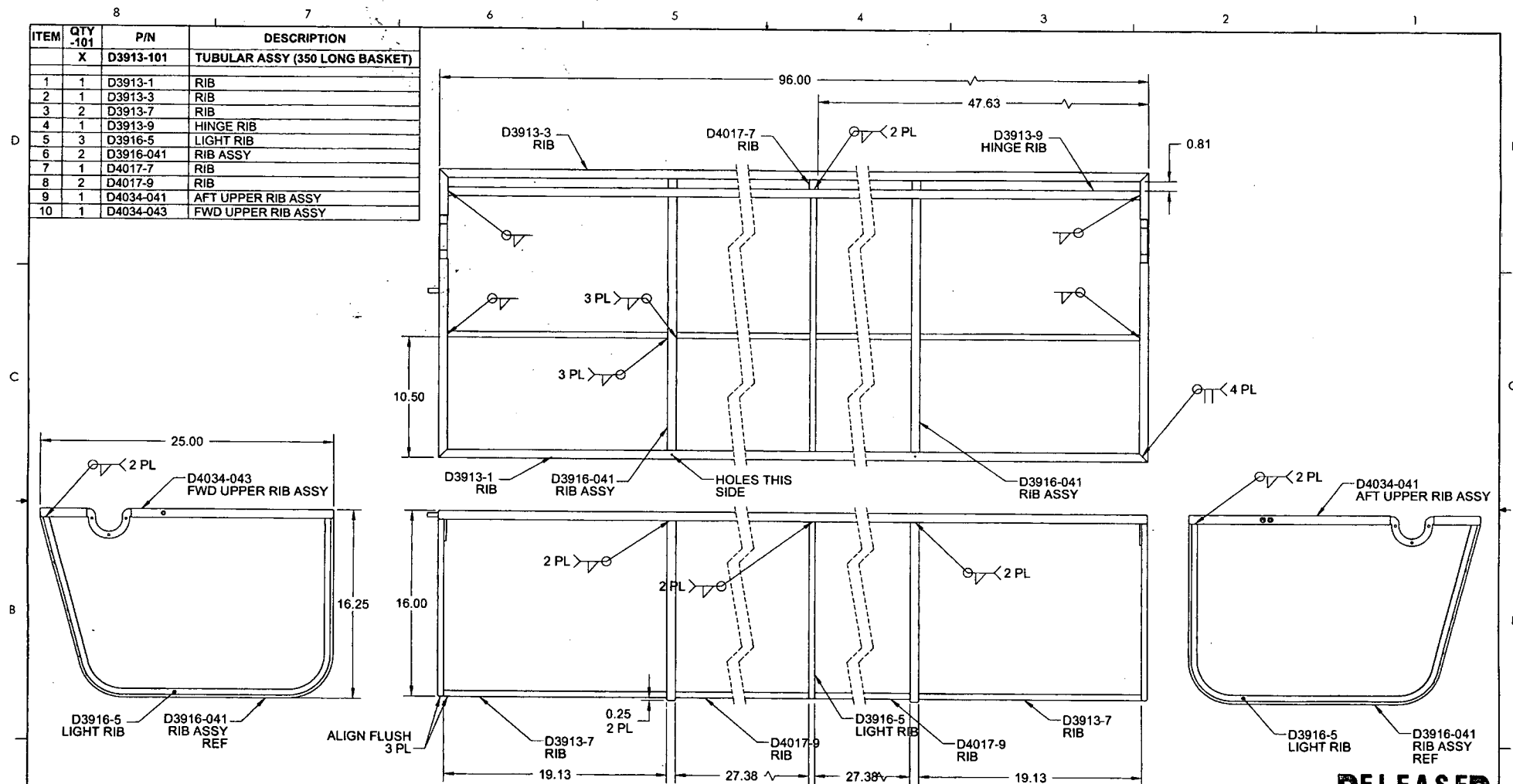
**DETAIL** D2-3  
D6-3

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

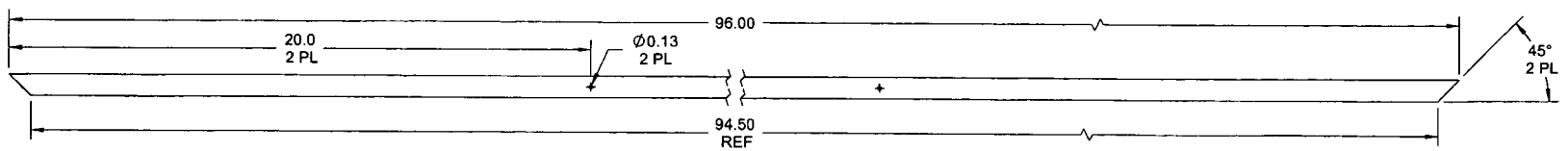
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

7/2/13

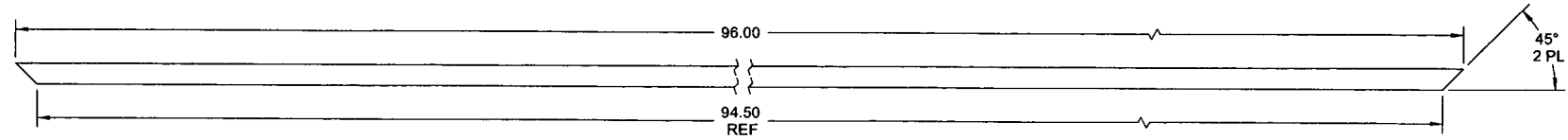
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DRAWN	JRH		
CHECKED	A	DRAWING NO.	REV. A
MFG. APPR.	A	D3913	SHEET 4 OF 6
APPROVED	A	TITLE	SCALE
DE APPR.	A	LONG BASKET BASE ASSY (350)	NTS
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2010-03-22

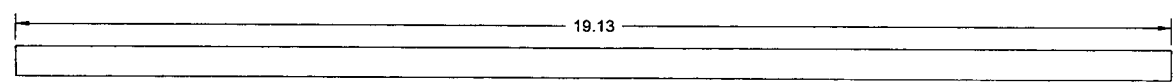
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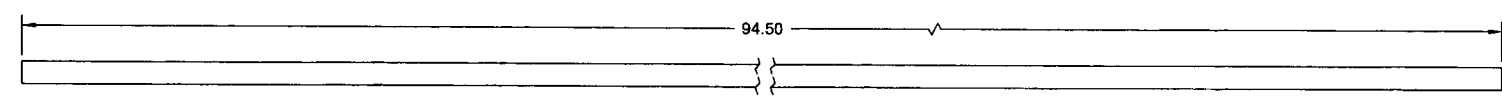
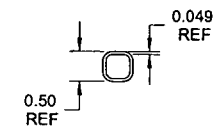
**D3913-1 RIB**



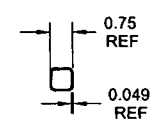
**D3913-3 RIB**



**D3913-7 RIB**



**D3913-9 HINGE RIB**



**NOTES:**

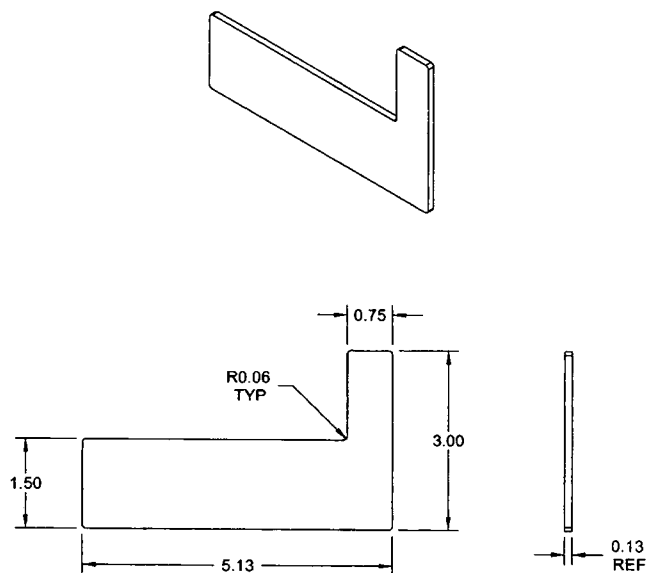
- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

712L3

**RELEASED**  
2010-03-22

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3913</b>	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>LONG BASKET BASE ASSY (350) NTS</b>	
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8 7 6 5 4 3 2 1



**D3913-15 WIDE HANDLE PLATE**

11213

**RELEASED**  
2010-03-22  
JNP

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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